

Work Order ID 52665

October 6, 2009 8:38:24 AM



Page 1

Item ID:	D3447-7 GN	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Clevis					
Start Date:	10/06/2009	Start Qty: 10.00		Cust Item ID:		
Required Date:	10/12/2009	Req'd Qty: 10.00		Customer:		
Reference:						

Approvals:	Process Plan: <u>ME</u>	Date: <u>09-10-06</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3447	Rev A								
100	Hardinge CNC LATHE SMALL	0.00							
	Hardinge								
	Memo	0.00							
	Turn as per Folio								
	& Dwg B67-43001 Dwg Rev: <u>A</u>								
	<u>DOSSAN</u>								
	<u>09-10-06</u>								
110	CONVENTIONAL LATHE	0.00							
	Lathe Conv								
	Memo	0.00							
	Turn 3.750" dimension to Ø0.975" Mill as per Dwg D3447 Deburr								
	<u>N/A</u>								
	<u>09-10-07</u>								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Memo	0.00							
	Quality Control								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3447-7

Accept



Setup Start



Revision ID: A

Item Name: Clevis

Stop



Start Date: 10/06/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/12/2009 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

SA 09/10/07



QC

Memo

0.00

Quality Control

10 0

140

Chemical Conversion Coat per QSI005 4.1

0.00

MO 09/10/16



HandFinish

Memo

0.00

Hand Finishing

110

150

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

12/8/14



Powdercoat

Memo

0.00

Powder Coating

Mask square section ☐ START TIME:

TEMPERATURE 150 ☐ FINISH TIME:

7:45pm ☐ OVEN 320

7 09/10/20

210 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: 3 Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D3447-7

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clevis

Start Date: 10/06/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/12/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

bk 09-10-20

(10)

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location *441*

0.00



Packaging

Memo

0.00

Packaging

09/10/21 (10) ~~10~~

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/21 ~~10~~
mf
09-10-21

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 52665

Parent Item: D3447-7RevA

Parent Item Name: Clevis

Start Date: 10/06/2009

Required Date: 10/12/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R1.250		Purchased	No			100	f	32.7121	4.6442			



6061-T6 Round Bar 1.250

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

32.7121

108876

9.6

109733

7.04

111321

13.7021

18295

2.37

Req. 10.7

4.41

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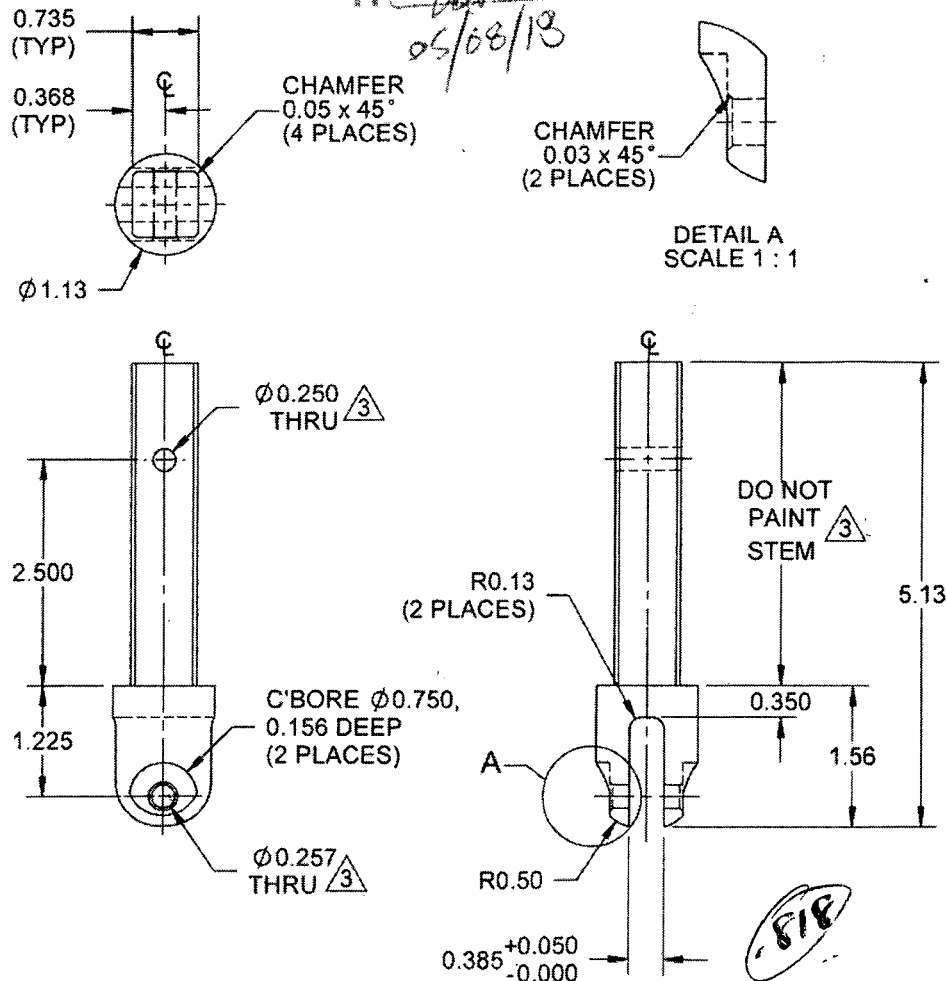
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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 3 OF 4
DATE 05.07.19	TITLE BLADE FOLD KIT PARTS		SCALE 1:2

**D3447-7 CLEVIS****SUPERCEDES PREMIER P/N B67-43001-145/-345****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.125)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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